



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-31702W24-PO

Job Sheet 185064



Part No: RBE105-31702W24-PO

Job Qty: 1 ea

Part Name: Tail Rotor Fork Shaft Check



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE105-31702W24 Rev.1 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	11/16/18	11/16/18	0.00	0.00	Purchasing		DEC 12 2018
110	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		DEC 12 2018
120	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC6		38
130	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		DEC 17 2018

Part Op 100 - Issue P/O: _____ MANUFACTURE RBE105-31702W24 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-31702W24P	Tail Rotor Fork Shaft Check	1 (1 ea)	100-Purchasing	S137419

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE105-31702W24P	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 12:53 PM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S137420



Part: RBE105-- 31702W24

Job No: 185064

Serial No/Batch: S137420

Revision: 1

Inspector:

Exp Date:

Instructions:

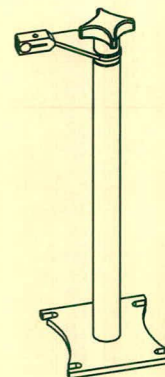
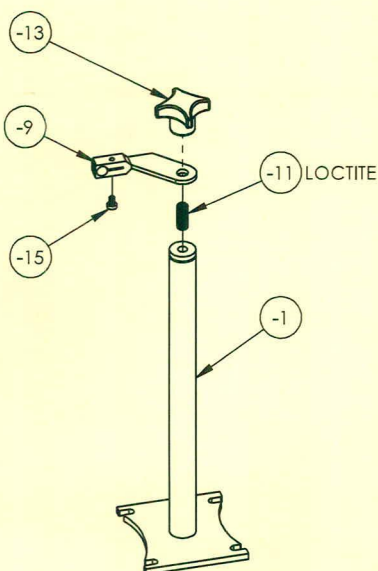
Date: 12/12/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	8/1/2016	RJC	JAG



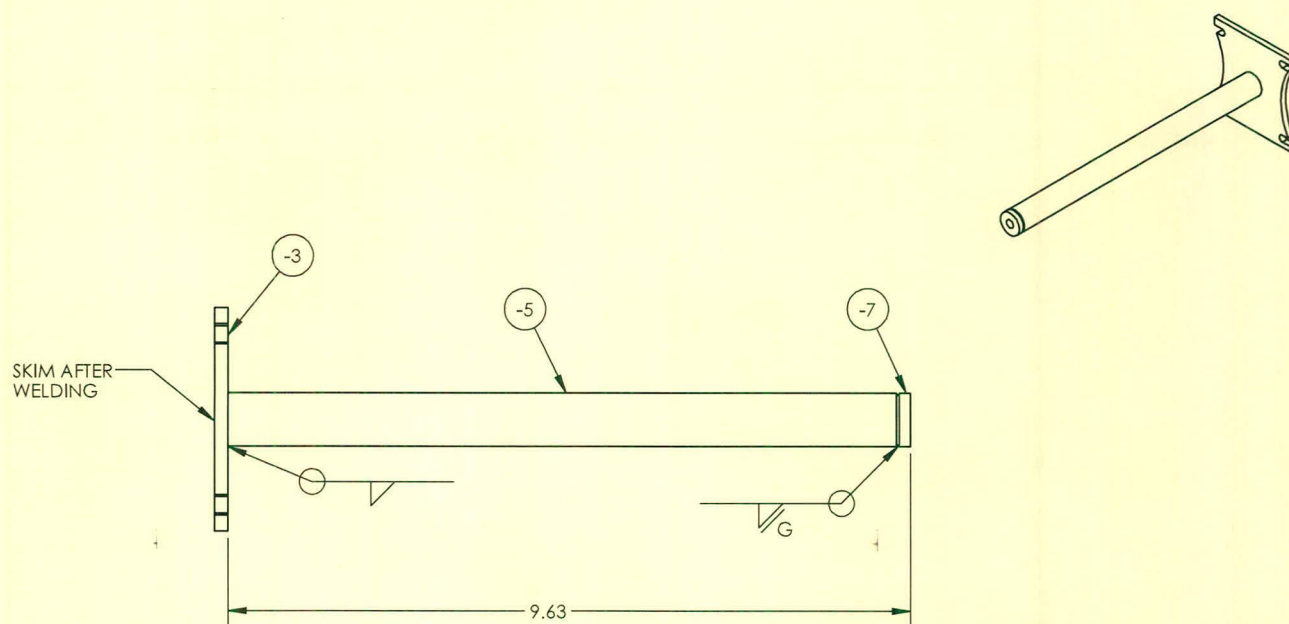
NOTE:
REF. EUROCOPTER T/N 105-31702W24.

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24	REV 1
MAT'L TREAT FINISH SPEC	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145	
SCALE 1:4	DATE 7/15/2016
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	WELDMENT			2
	1		-3		BASE PLATE	A36/1018/1020 HR		3
	1		-5		TUBE	DOM		4
	1		-7		CAP	A36/1018/1020 HR		5
			-9	1	ARM	A36/1018/1020 HR		6
		B/O	-11	1	SET SCREW	STEEL	M8 X 1.25 X 20mm (MCMaster-CARR #93245A145)	1
		B/O	-13	1	FOUR ARM KNOB	PHENOLIC	M8 X 1.25, 40mm (MCMaster-CARR #6390K23)	1
		B/O	-15	1	SOCKET HARD CAP SCREW	STEEL	M4 X .7 X 6mm (MCMaster-CARR #90327A111)	1
	ASSY -1							

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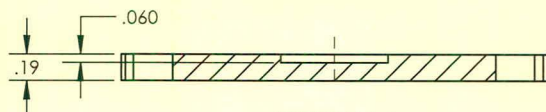
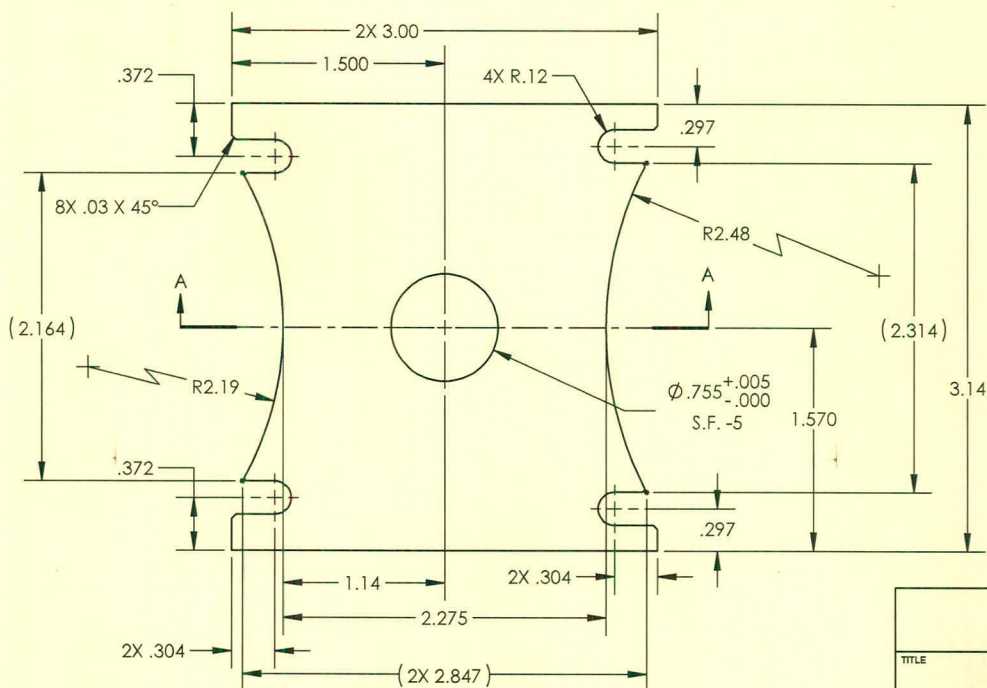
REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-1	REV 1
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:2	DATE 7/15/2016
SHEET 2 OF 6	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



SECTION A-A

(-3)

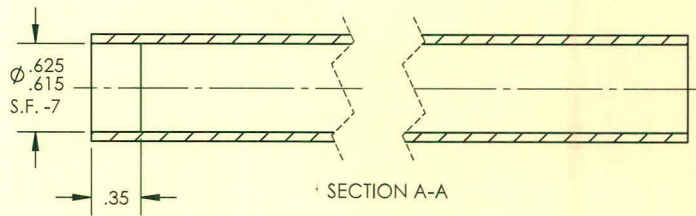
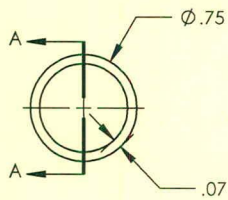
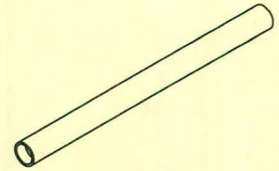
BASE PLATE



TITLE		MEASURING DEVICE	
DWG NO.		RBE105-31702W24-3	
REV		1	
MATERIAL		A36/1018/1020 HR	
FINISH		SEE -1	
SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 ANGLES ± 1° SURFACES = 125	
DRAWN BY:		CLOUGH	
CHECKED:		DUERFELDT	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:1	
DATE		7/15/2016	
SHEET		3 OF 6	

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REVISIONS			
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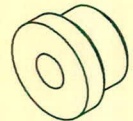
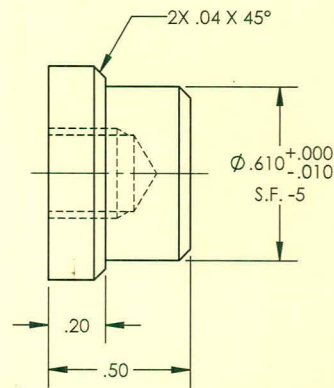
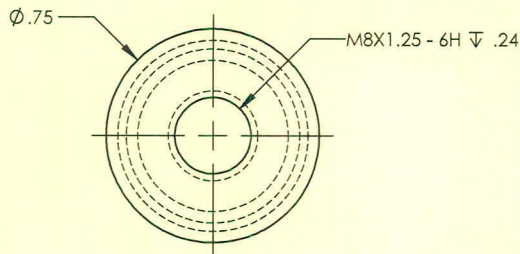
(-5)

TUBE

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-5	REV 1
MAT'L DOM HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 7/15/2016
SHEET 4 OF 6	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED

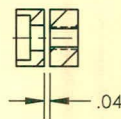
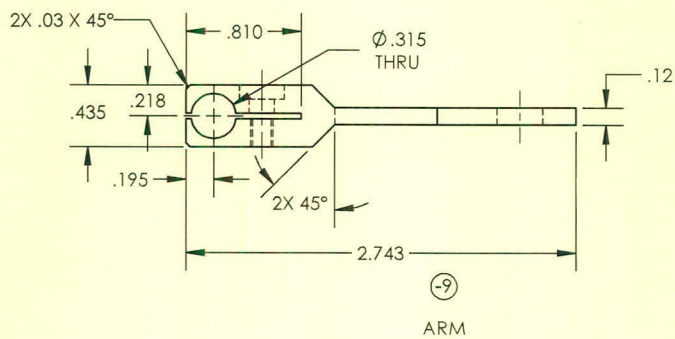
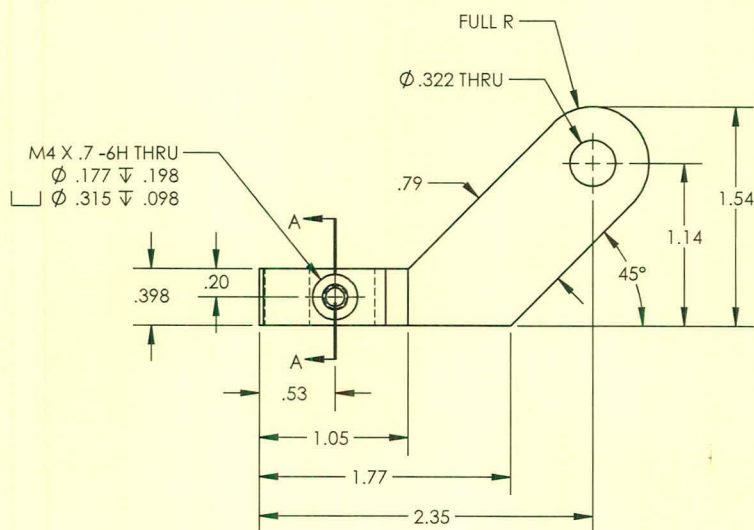


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CAP

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-7	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER
QA APPR: LINDSAY	ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 2:1	EC145
DATE 7/15/2016	SHEET 5 OF 6

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



SECTION A-A

DART AEROSPACE	
TITLE MEASURING DEVICE	
DWG NO. RBE105-31702W24-9	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 7/15/2016
SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041411
PO Date: 10/22/18
Due Date: 12/14/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185055	RBE105-14101W2P			Outer Needle Bearings Extractor	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,100.00/Ea	\$4,100.00
Line Item Note REV 1													
2	185058	RBE105-14101W18P			Pressing-In Tool	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$1,950.00/Ea	\$1,950.00
Line Item Note REV 1													
3	185059	RBE105-45045W1P			Trammel	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,900.00/Ea	\$4,900.00
Line Item Note REV 1													
4	185061	RBE105W27P			Main Gear Box Hoisting Device	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
5	185063	RBE105-31501W6P			Puller	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$820.00/Ea	\$820.00
Line Item Note REV 1													
6	185064	RBE105-31702W24P			Tail Rotor Fork Shaft Check	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
7	185065	RBE105-13101W3P			Disassembly / Assembly - Rotating Control Rod	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$5,050.00/Ea	\$5,050.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185106	RBE105-14101W12-1P			Mounting Shaft Assembly	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note: Sub assy on part # RBE105-14101W12 REV 1 1 X DEC 12 2018													
9	185107	RBE105-14101W12-9P			Mounting Base	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note: Sub assy on part # RBE105-14101W12 REV 1 1 X DEC 12 2018													
												Grand Total: \$17,860.02	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 12/11/18 9:11 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24372
Shipment Date: 11-Dec-2018
Ship Via: Pick up at METEC

Customer Code: DART
Phone: (613) 632-9577

Terms: Net 60 Days

----- Quantity -----									
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>	
1	1	1	0	0	EA	DART-RBE105-31702W24P Measuring Device (Tail Rotor Fork Shaft Check) Order No: 3161 Order Date: 11/08/18 PO Number: PO041662	1	3161-01	DAS 38 9-89
1	1	1	0	0	EA	DART-RBE105-31702W24P Measuring Device (Tail Rotor Fork Shaft Check) Order No: 3282 Order Date: 12/07/18 PO Number: PO041411	1	3282-01	

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

 Packing Clerk's Signature
 Metec Metal Technology Inc

 Received In Good Order By

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBE105-31702W24P Rev. 1</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) December 7, 2018 <i>MLee</i> Completed By	
Description Work Order Deviation		Disposition			
RBE105-31702W24-5 and -7 must be manufactured as one piece from 303/304 Stainless Steel rod. RBE105-31702W24-3 must be manufactured from 303/304 Stainless Steel plate. Zinc Plate is no longer required		This deviation is acceptable. No change to fit form or function of the tool.			
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
1	DART-RBE105-31702W24P	MEASURING DEVICE	1	41662
1	DART-RBE105-31702W24P	MEASURING DEVICE	1	41411
Material supplied by METEC				

DAS
38
9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, December 11, 2018

UNITED STATES DEPARTMENT OF AGRICULTURE

OFFICE OF THE SECRETARY

STATEMENT OF WORK

TO

THE SECRETARY

OF AGRICULTURE

WASHINGTON, D.C.

1917

1917

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